

Work Order ID 150828

Thursday, September 08, 2016 8:33:50 AM

150828

AMOD
DG

Page 1

Item ID: D412-630-032DG Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green
Start Date: 9/30/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 10/31/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference: **DAS 21 9-89**

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 08 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						DAS 21 9-89	16-10-20	16
IIN D412-630	O	DAS 6 9-89							
100	Document Control	0.00				DAS 27 9-89			
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004								
									NOV 09 2016
110	Small Fab	0.00							
110	Small Fab								
Small Fab	Memo	0.12							
Small Fab	Assemble as per IIN D412-630								
	****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****								
	A/R MS20995C41 batch: M131371								

3x **DAS 36 9-89** **16/11/07**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.01							
Quality Control	****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab. ENSURE STEP IS A LH: _____								DAS 38 9-89 NOV 07 2016
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging									DAS 28 9-89 NOV 08 2016
140	QC4- 100% Inspect kits for completeness	0.00							
140									
QC	Memo	0.02							
Quality Control									DAS 27 9-89 NOV 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00		3					
Packaging	Identify and pack for shipping as per PPP D412-630-032 ENSURE STEP IS A RH: Location;FG034 sold								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.05							
Quality Control									

DAS 27 9-30
NOV 09 2016

DAS 21 9-30
NOV 10 2016

2m 16/11/9

DQA: _____ Date: _____



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Picklist Print

Thursday, September 08, 2016 8:33:54 AM

Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
 10.05.28 added route seq DD verf: EC IPP Rev: E 11.06.01
 removed qty1 an310-4 EC verified by: DD IPP REV: F 16.06.23 AS PER
 IIN REV. O DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 *AN310-4* Nut		Purchased	No			110	Each	169.0000	1	3		OCT 26 2016	DAS 6 9-89
Location Loc Qty Loc Code													
GA 25													
M127815 25													
OVER007 100													
M135442 100													
ST331 44													
M134955 44													
AN310-7 *AN310-7* Nut		Purchased	No			110	Each	65.0000	1	3		OCT 26 2016	DAS 6 9-89
Location Loc Qty Loc Code													
ST331 65													
124198 25													
m120124 40													
AN4C14 *AN4C14* Bolt		Purchased	No			110	Each	32.0000	1	3		OCT 26 2016	DAS 6 9-89
Location Loc Qty Loc Code													
ST344 32													
m131264 2													
m135084 30													

70

135724 OCT 26 2016

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Picklist Print

Page 2

Thursday, September 08, 2016 8:33:54 AM

Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

AN4CH3 Purchased No 110 Each 83.0000 2 6

AN4CH3

Bolt

**

OCT 26 2016 ^{DAS} 6 9-89

Location

Loc Qty

Loc Code

ST346

83

M132124

8

M135482

75

D3443-041

Manufactured No

110 Each

1.0000

1

3

D3443-041

Strut Weldment Assembly

**

16/11/07 ^{DAS} 36 9-89

Location

Loc Qty

Loc Code

ST525

1

144279

1

D3443-043

Manufactured No

110 Each

1.0000

1

3

D3443-043

Strut Weldment Assembly

**

16/11/07 ^{DAS} 36 9-89

Location

Loc Qty

Loc Code

ST525

1

145453

1

D3443-9

Manufactured No

110 Each

115.0000

2

6

D3443-9

Pin

**

OCT 26 2016 ^{DAS} 6 9-89

Location

Loc Qty

Loc Code

ST037

115

145541

14

149322

101

Thursday, September 08, 2016 8:33:54 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Picklist Print

Thursday, September 08, 2016 8:33:54 AM

Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

D3454-7 Manufactured No 110 Each 124.0000 2 6

D3454-7

Bushing

**

Location Loc Qty Loc Code

ST037 22

144631 22

ST038A 102

149466 102

D3455-1 Manufactured No 110 Each 373.0000 2 6

D3455-1

Spacer

**

Location Loc Qty Loc Code

ST037 66

147371 66

ST038A 307

149364 307

D3463-042 Manufactured No 110 Each 2.0000 1 3

D3463-042

Step Weldment Assembly

**

Location Loc Qty Loc Code

ST386 2

144282 2

D3465-1 Manufactured No 110 Each 96.0000 1 3

D3465-1

Washer

**

Location Loc Qty Loc Code

ST038 96

148257 44

149356 52

OCT 26 2016
DAS 6 9-89

OCT 26 2016
DAS 6 9-89

16/11/07
DAS 36 9-89
B149380 (3x)

OCT 26 2016
DAS 6 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
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LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Thursday, September 08, 2016 8:33:54 AM

Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

MS24665-227

Purchased

No

110

Each

105.0000

1

3

MS24665-227

Cotter Pin

**

OCT 26 2016

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

16

111041

16

ST289

89

m127831

89

MS24665-302

Purchased

No

110

Each

29.0000

1

3

MS24665-302

Cotter Pin

**

OCT 26 2016

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

15

120521

15

ST288

14

m134738

14

AN310-4

Purchased

No

130

Each

169.0000

1

3

AN310-4

Nut

**

OCT 31 2016

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

100

M135442

100

ST331

44

M134955

44

DAS
27
9-89

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Thursday, September 08, 2016 8:33:55 AM

Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

AN310-5

Purchased

No

130

Each

25.0000

2

6

AN310-5

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

ST331

25

m129706

9

m131320

16

130

Each

1,277.000

3

9

**

m135070

OCT 31 2016

DAS
6
9-89

DAS
28
9-89

AN3C5A

Purchased

No

AN3C5A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

199

M134955

174

M135470

25

OVER002

800

M135297

600

M135442

200

ST350

273

M133234

1

M134676

272

130

Each

12.0000

1

3

**

135704

OCT 31 2016

DAS
6
9-89

DAS
28
9-89

AN44-C12

Purchased

No

AN44-C12

Eye Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

3

124829

3

ST339

9

M132879

4

M135297

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____						

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Thursday, September 08, 2016 8:33:55 AM

Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

AN4C15 Purchased No

130

Each

29.0000

1

3

AN4C15

Bolt

**

135704

OCT 31 2016

DAS 6 9-89

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

OVER002

15

M135046

15

ST343

14

M1134567

14

AN5C11 Purchased No

130

Each

11.0000

1

3

AN5C11

BOLT

**

135722

OCT 31 2016

DAS 6 9-89

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST338

11

M134887

11

AN5C15 Purchased No

130

Each

14.0000

1

3

AN5C15

BOLT

**

135704

OCT 31 2016

DAS 6 9-89

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST337

14

M132317

4

M135297

10

D3454-1 Manufactured No

130

Each

58.0000

1

3

D3454-1

Bushing

**

OCT 31 2016

DAS 6 9-89

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST037

58

146027

10

149447

48

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Thursday, September 08, 2016 8:33:55 AM

Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

D3454-3

Manufactured No

130

Each

123.0000

2

6

**

DAS
6
9-89

DAS
28
9-89

OCT 31 2016

D3454-3

Bushing

DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

123

121223

22

149416

101

D3454-5

Manufactured No

130

Each

117.0000

2

6

**

DAS
6
9-89

OCT 31 2016

DAS
28
9-89

D3454-5

Bushing

DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

13

148239

13

ST038A

104

145571

3

149326

101

D3455-1

Manufactured No

130

Each

373.0000

4

12

**

DAS
6
9-89

OCT 31 2016

DAS
28
9-89

D3455-1

Spacer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

66

147371

66

ST038A

307

149364

307

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
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Root Cause		FAULT CATEGORY																							
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OTHER : _____																									

Picklist Print

Thursday, September 08, 2016 8:33:55 AM

Page 8

Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

D3455-3

Manufactured No

130

Each

117.0000

2

6

D3455-3

Spacer

**

DAS 6 28
9-89 9-89

OCT 28 2016

DAS 27
9-89

AS 7
89

Location

Loc Qty

Loc Code

ST037

95

146067

11

149459

84

ST038A

22

149312

22

D3462-042

Manufactured No

130

Each

2.0000

1

3

D3462-042

Bracket Assembly

**

DAS 6 28
9-89 9-89

NOV 17 2016

149442

DAS 27
9-89

Location

Loc Qty

Loc Code

ST038

2

146512

2

D3672-5

Manufactured No

130

Each

622.0000

1

3

D3672-5

Washer, Phenolic

**

DAS 6 28
9-89 9-89

OCT 28 2016

DAS 27
9-89

Location

Loc Qty

Loc Code

FG

8

44679

8

ST049

234

35521

234

ST051A

380

50354

380

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Picklist Print

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Page 9

Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

MS21043-3

Purchased

No

130

Each

1,202.000

3

9

MS21043-3

Nut

DAS 6 28
9-89 9-89

OCT 2 8 2016

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	11	
m130673	11	
GA	235	
m133990	235	
ST302	807	
m135058	7	
m135442	400	
m135544	400	
ST304	69	
m131340	69	

DAS 27
9-89

MS24665-227

Purchased

No

130

Each

105.0000

****n**

DAS 6 28
9-89 9-89

OCT 2 8 2016

MS24665-227

Cotter Pin

Location

Loc Qty

Loc Code

GA	16	
111041	16	
ST289	89	
m127831	89	

DAS 27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

Picklist Print

Page 10

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Work Order ID: 150828

150828

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

MS24665-229

Purchased

No

130

Each

71.0000

2

6

MS24665-229

Cotter Pin

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

5

118234

5

ST289

66

m132123

66

130

Each

478.0000

7

21

NAS1149C0363R

Purchased

No

NAS1149C0363R

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

265

114742

6

m133077

259

GA

213

m133077

213

130

Each

422.0000

1

3

NAS1149C0563R

Purchased

No

NAS1149C0563R

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST265

422

m131697

422

**

**

**

DAS
6
9-89
DAS
28
9-89

DAS
6
9-89
DAS
28
9-89

DAS
6
9-89
DAS
28
9-89

Thursday, September 08, 2016 8:33:55 AM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
1	1	D3672-5	WASHER (OR NAS1515H5)
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
2	2	AN3C5A	BOLT
1	1	AN3C6A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	NAS1149C0363R	WASHER (OR AN960C10)
1	1	NAS1149C0563R	WASHER (OR AN960C516)
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP.
SEE FIGURE 13B (D412-630-023/-024 KITS) OR FIGURE 16B (D412-630-033/-034 KITS).